

Work Order ID 101989

May-22-13 10:50:37 AM

ASAD
101989

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Item ID: D4771-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate Assembly

Start Date: 5/22/13 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/24/13 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4771	A								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120		0.00							
120									
Large Fab	Memo	0.00							
Large Fab	1- Weld hardcoat on bar as per dwg A/R 2059b hardcoat Batch#: <i>M125337</i>								
	2- Weld bar to wearplate as per dwg A/R s.s. rod Batch #: <i>M122357</i>								
	3- Transfer drill drain holes as per dwg								

Q Q 13-5-09

Q Q 13-5-09

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Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate Assembly

Start Date: 5/22/13

Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/24/13

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00

130

QC

Memo

0.00

Quality Control

(2) 13-05-30 (DAS 09 0-89)

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

(2) 13-05-30 (DAS 09 0-89)

150

0.00

150

Small Fab

Memo

0.00

Small Fab

Apply Rockguard on entire concave surface as per dwg
A/R Rockguard Batch: 125226

2 0 0 (13-5-31)

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Item ID: D4771-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate Assembly
 Start Date: 5/22/13 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 5/24/13 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00 13.63				2			
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>FP-002</u> Memo	0.00 0.00				x2			13/06/03
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							13/6/4

13-06-3

Picklist Print

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Work Order ID: 101989

Parent Item: D4771-041

Parent Item Name: Wearplate Assembly

Start Date: 5/22/13

Required Date: 5/24/13

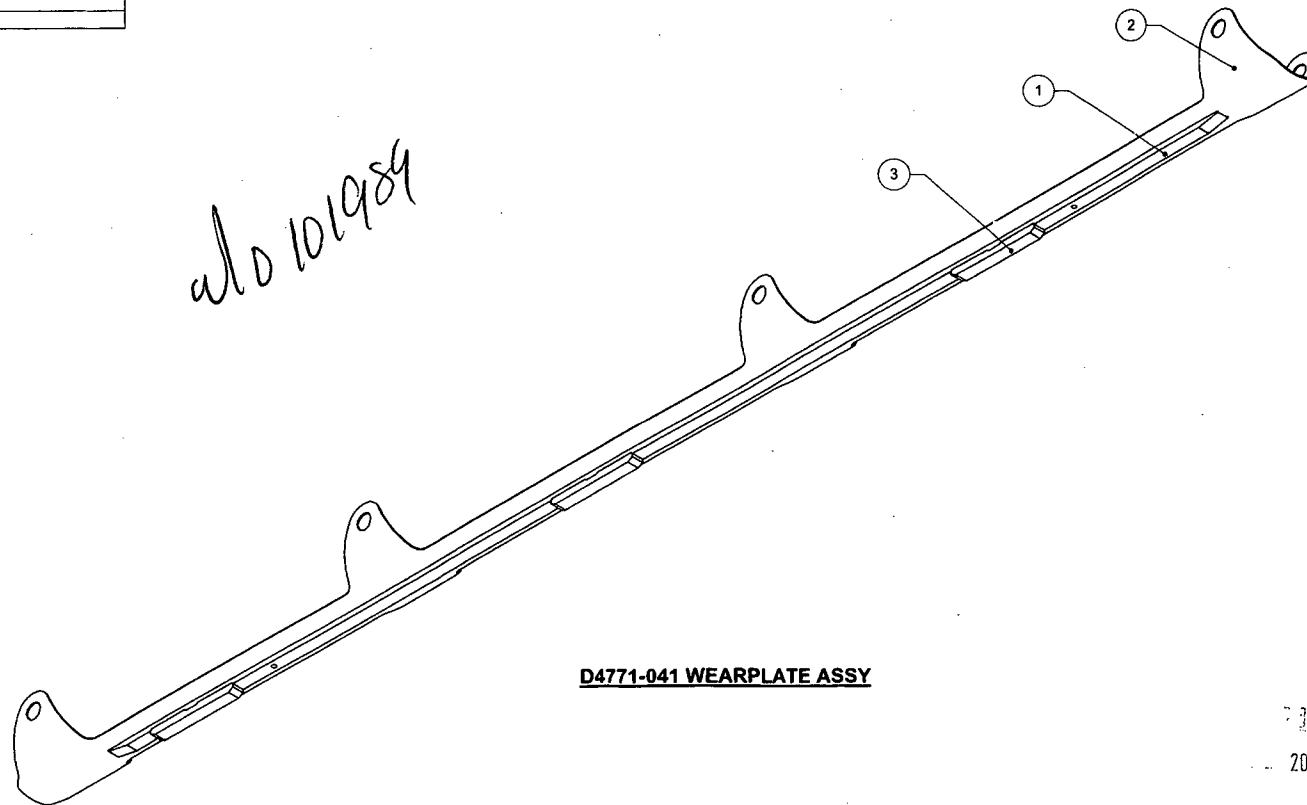
Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.03.27 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4770-5 Bar		Manufactured	No	101995X2			Each	0.0000		EL 2 13-5-29			
D4771-1 Wearplate		Manufactured	No	101994X2			Each	0.0000		EL 2 13-5-29			

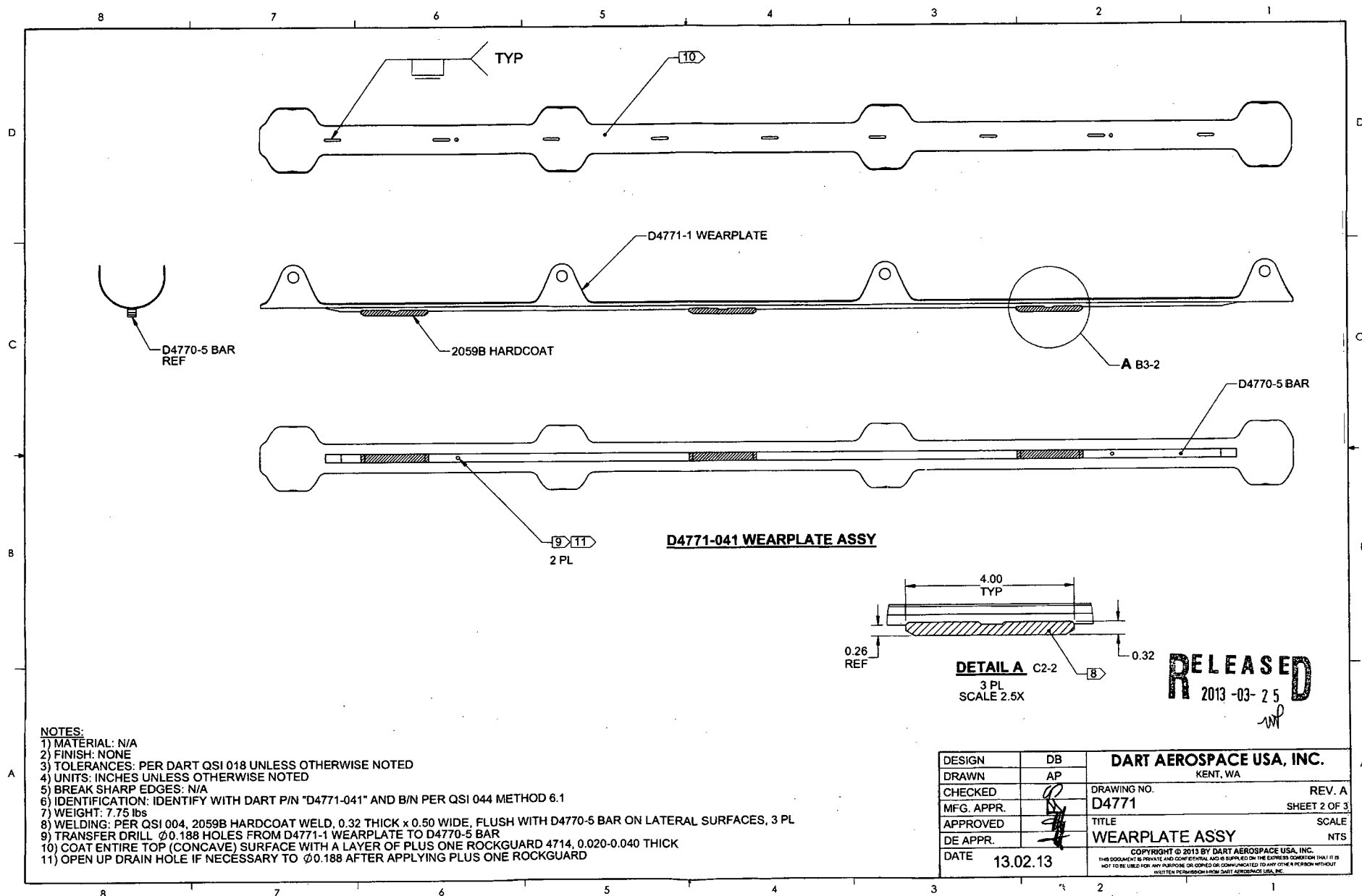
ITEM	QTY -041	P/N	DESCRIPTION
	X	D4771-041	WEARPLATE ASSY
1	1	D4770-5	BAR
2	1	D4771-1	WEARPLATE
3	A/R	2059B	HARDCOAT



D4771-041 WEARPLATE ASSY




RELEASED
2013-03-25

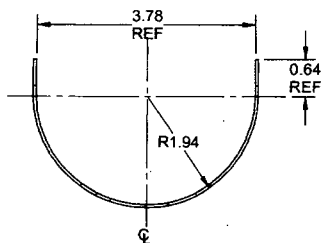
A	NEW ISSUE	AP	13.02.13
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4771	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	13.02.13	<small>COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



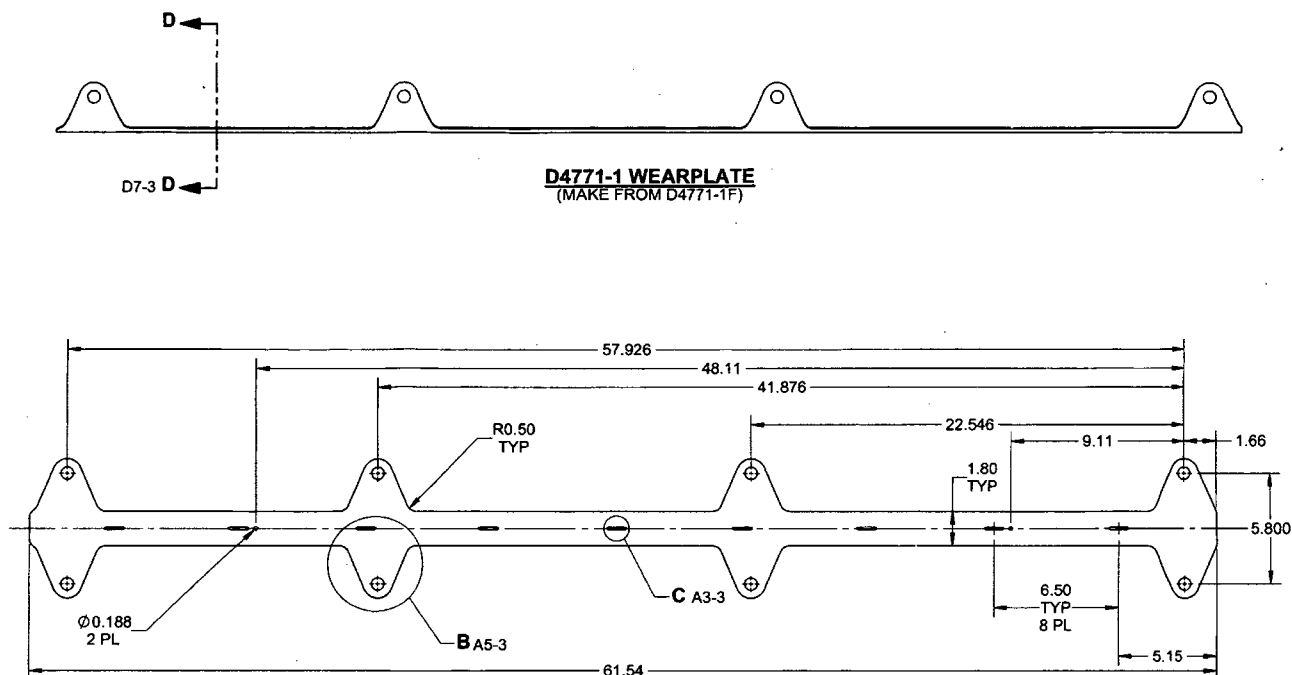
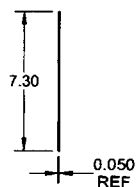
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4771-041" AND B/N PER QSI 044 METHOD 6.1
- 7) WEIGHT: 7.75 lbs
- 8) WELDING: PER QSI 004, 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D4770-5 BAR ON LATERAL SURFACES, 3 PL
- 9) TRANSFER DRILL $\varnothing 0.188$ HOLES FROM D4771-1 WEARPLATE TO D4770-5 BAR
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) OPEN UP DRAIN HOLE IF NECESSARY TO $\varnothing 0.188$ AFTER APPLYING PLUS ONE ROCKGUARD

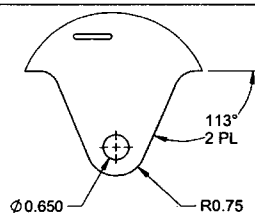
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MFG. APPR.		D4771	SHEET 2 OF 3
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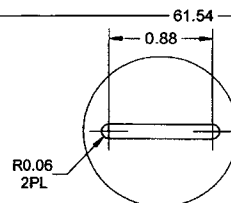
SECTION D-D D5-3
SCALE 2X



D4771-1 WEARPLATE
(MAKE FROM D4771-1F)



DETAIL B B4-3
8 PL
SCALE 2X



DETAIL C C4-3
9 PL
SCALE 2X

D4771-1F WEARPLATE
(FLAT PATTERN)

RELEASED
2013-03-25

NOTES:

- 1) MATERIAL : AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH : NONE
- 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS : INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
- 6) IDENTIFICATION : NONE
- 7) WEIGHT : 2.95 lbs
- 8) IT IS ACCEPTABLE TO OVERBEND D4771-1 UP TO 2 DEG OR UNDERBEND UP TO 5 DEG

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MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 3	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSY	NTS
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